

Work Order ID 60337

July 6, 2010 7:27:25 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4102-1

Accept



Setup Start



Revision ID:

Item Name: SHIM

Stop



Start Date: 07/07/2010 Start Qty: 2.00



Cust Item ID:



Required Date: 28/07/2010 Req'd Qty: 2.00

Customer:

Reference:

Ref 10-07-06

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4102

REV. PRELIM

PA4

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

amk 10/07/09

2 15

Jeaspa Bandsaw

4.950" long

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA945

FOLIO REV: *AA*

DWG REV: *PAH*

amk 10/07/14

DEBURR



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: / Date: 10/7/15
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/07/14	110	1 part scrap. wrong drill R.C. preliminary drawing re-design the hole. Folio drill bit size was 0.191" & not changed to 0.129" per PA4 & C. Folio.	<u>/</u> QS/ML	destroy and replace Qty: 1 Batch: M110680	<u>mf</u> 10/07/14	<u>S</u> 10/07/15	<u>/</u> FRS/ML	<u>/</u> 10/07/15

NOTE: Date & initial all entries

Work Order ID 60337

July 6, 2010 7:27:25 AM



Page 2

Item ID: D4102-1

Accept



Setup Start



Revision ID:

Stop



Item Name: SHIM

Start Date: 07/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 28/07/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	□□								
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

Sh 10/07/14

*- inspected to pay
Dy only
8/10/2015 (2)*

Sh 10/02/14

x2 0

Work Order ID 60337

July 6, 2010 7:27:25 AM



Page 3

Item ID: D4102-1

Accept



Setup Start



Revision ID:

Stop



Item Name: SHIM

Start Date: 07/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 28/07/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00 *inspect to pay*



QC

Memo

0.00 *Dr only
8/15/10*

Quality Control

160

Identify as per dwg & Stock Location: *Prep*

0.00



Packaging

Memo

0.00 *Ind 10-07-21*

Packaging

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00 *PA4 test
10.07.22
Rev. A.
10.07.30*

Quality Control

*MF
10-7-21*

Picklist Print

July 6, 2010 7:27:24 AM

Page 1

Work Order ID: 60337

Parent Item: D4102-1

Parent Item Name: SHIM



Start Date: 07/07/2010

Required Date: 28/07/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-07-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.00 0		Purchased	No			100	f	16.5000	0.042	0.088421			



6061-T6 Bar .250 x 4.00



Location

Loc Qty

Loc Code

MAT

16.5

→ 110680

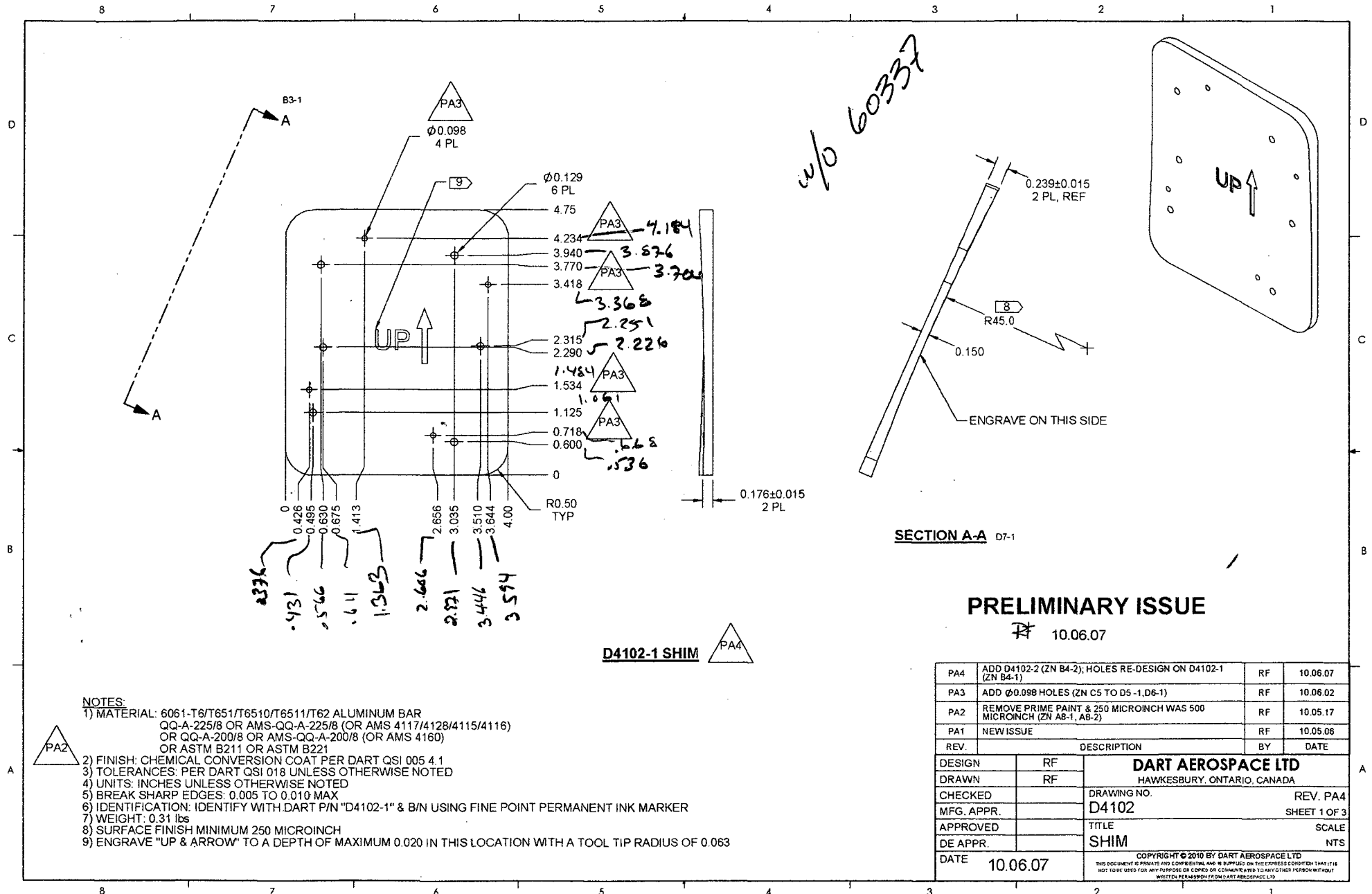
0.5

114608

16

.088421 *ml*
10/02/09

POSITIVE RECALL
EFFECTIVE 10-07-06 AUTH *u*
RELEASED _____ DATE _____



Receiving Report

Date: 9/10/28

Batch No: M110650

Supplier: MOCA

Dart P/O: 8075

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipping Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ☒ N/A ☐
 Work Order 026062 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M02024 T35032		792	0	0	192	
M6061 T6 B250X460		60	0	0	60	
M6061 T6 70035T465		108	0	0	108	

M6061 T6 T70035T465

Initials of Receiver (If statement OK) Level 12 [Signature]

Production/Admin: 09/10/2103
 Date: 10/29
 Received/Costing: RCP
 Initial: CX

Location _____

M7075 T6 B1500X460

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date
Feb 3, 2009

Page
1

Receipt Number
RCP00010129

Purchase From:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00008045

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M303R0750	303 Round Bar 0.750 NOTE: AISI 304/316 NOT ACCEPTABLE MATERIAL: AISI 303 ROUND BAR B/N110680	124.0000	f	3.166666	392.67	Feb 03, 2009
	M6061T6B0250X0	6061-T6 Bar .250 x 4.00 PER AMS-QQ-A-200/8 OR AMS 4160 PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR B/N110680	20.0000	f	2.650000	53.00	Feb 03, 2009 ✓
	M6061T6T1250W1	ALUM. RD TUBING 1.2 AS ABOVE B/N110680	160.0000	f	1.150000	184.00	Feb 03, 2009 ✓
	M6061T6T1500W1	6061T6 RD TUBE 1.50 X AS ABOVE B/N110680	60.0000	f	1.500000	90.00	Feb 03, 2009 ✓
	M6061T6TS1000W	6061T6 SQ TUBE 1.00 x OR AMS 4160 **** FLAT SQUARE EDGE**** AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 SQUARE TUBING PER AMS-QQ-A-225/8 OR MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 B/N110680	140.0000	f	1.100000	154.00	Feb 03, 2009 ✓
	M304TR0875W065	304 round tube .875 x .0 MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING B/N110680	120.0000	f	8.750000	1,050.00	Feb 03, 2009 ✓

Comments:

PLEASE DO NOT SHIP ON THE 28TH & 29TH OF JANUARY



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I006166

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

Currency		Sales Person		Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS		(613) 632-5200	(613) 632-1053	8045	
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W006839	NET 30 DAYS		NIR:R-557065-1		01/23/09	01/28/09	01/28/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINUM FLATS AFL 6061 T6 1/4" x 4" x R/L ✓ 20' 24 LB / 1 PC	L006696	18836	1
7		PC	ALUMINUM SQUARE TUBE AST 6061 T6 SC 1" x .120" x R/L ✓ 20' 68 LB / 7 PC	L021366	5632	7
3		PC	ALUMINUM ROUND TUBE ATU 6061 T6 1.5" x .125" x R/L 20' 38 LB / 3 PC ✓	L015484	08050785A	3
8		PC	ATU 6061 T651 1.25" x .120" x R/L 20' 81 LB / 8 PC ✓	L021367	383 ✓ S.F. 09/01/30	8
10		PC	STAINLESS ROUNDS SRB 303 3/4" x R/L 12'4" 186 LB / 10 PC ✓	L020858	16486	10
Bundles: 3				Total Weight:		397 LB.

Received by: _____

Date: _____

Signature: _____



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I006166

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

Currency		Sales Person		Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS		(613) 632-5200	(613) 632-1053	8045	
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W006839	NET 30 DAYS		NIR:R-557065-1		01/23/09	01/28/09	01/28/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINUM FLATS AFL 6061 T6 1/4" x 4" x R/L ✓ 20' 24 LB / 1 PC	L006696	18836	1
7		PC	ALUMINUM SQUARE TUBE AST 6061 T6 SC 1" x .120" x R/L ✓ 20' 68 LB / 7 PC	L021366	5632	7
3		PC	ALUMINUM ROUND TUBE ATU 6061 T6 1.5" x .125" x R/L 20' 38 LB / 3 PC ✓	L015484	08050785A	3
8		PC	ATU 6061 T651 1.25" x .120" x R/L 20' 81 LB / 8 PC ✓	L021367	383 ✓ S.F. 09/01/30	8
10		PC	STAINLESS ROUNDS SRB 303 3/4" x R/L 12'4" 186 LB / 10 PC ✓	L020858	16486	10
Bundles: 3				Total Weight:		397 LB

Received by: _____

Date: _____

Signature: _____



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I006135

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY, ON
K6A 1K7
Contact:

HAWKESBURY, ON
K6A 1K7
Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

DO NOT SHIP WILL ADVISE
HOLD

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS	(613) 632-5200	(613) 632-1053	CHANTAL 8045	
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W002587	NET 30 DAYS		TARGET	10/23/08	11/21/08	01/28/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
6		PC	316L SMLS 7/8" OD .065 X 20' 120.00 FT / 6 PC FUEL SURCHARGE	L016423	YTO60922	6
Bundles: 1				Total Weight:	LB,	

Received by: _____ Date: _____ Signature: _____

DART

Purchase Order

Date Jan 23, 2009	Page 1
Purchase Order Number PO00008045	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
6696/23

Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Jan 23, 2009	N30	yours	Jan 30, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
192.0000	M2024T3S032	2024-T3 .032 sheet Comments: MATERIAL: 2024-T3 ALUMINUM SHEET	30/01/2009	No	3.645833	sf	700.00
✓ 120.0000	M303R0750	303 Round Bar 0.750 Comments: MATERIAL: AISI 303 ROUND BAR NOTE: AISI 304/316 NOT ACCEPTABLE	30/01/2009	No	3.166666	f	380.00
✓ 20.0000	M6061T6B0250X040	6061-T6 Bar .250 x 4.00 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 PER AMS-QQ-A-200/8 OR AMS 4160	30/01/2009	No	2.650000	f	53.00
60.0000	M6061T6B0250X060	6061-T6 Bar .250 x 6.00 Comments: AS ABOVE	30/01/2009	No	4.050000	f	243.00
108.0000	M6061T6T0625W065	6061-T6 RD Tube .625 x . Comments: MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 ****SEAMLESS TUBING****	30/01/2009	No	4.770833	f	515.25
60.0000	M6061T6T1000W065	6061T6 RD TUBE 1.00 x . Comments: AS ABOVE	30/01/2009	No	5.320833	f	319.25
✓ 160.0000	M6061T6T1250W125	ALUM. RD TUBING 1.250 Comments: AS ABOVE	30/01/2009	No	1.150000	f	184.00
✓ 60.0000	M6061T6T1500W125	6061T6 RD TUBE 1.50 X . Comments: AS ABOVE	30/01/2009	No	1.500000	f	90.00
✓ 140.0000	M6061T6TS1000W12	6061T6 SQ TUBE 1.00 x 1 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62	30/01/2009	No	1.100000	f	154.00

1/29/09

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

11/10/08

Continued on next page...

DART

Purchase Order

Date Jan 23, 2009	Page 2
Purchase Order Number PO00008045	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Jan 23, 2009	N30	yours	Jan 30, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
80.0000	M304TR0875W065	SQUARE TUBING PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160 **** FLAT SQUARE EDGE**** 304 round tube .875 x .065 Comments: MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING	30/01/2009	No	8.750000	f	700.00
12.0000	M7075T6B1500X150	7075 T6 BAR 1.500 x 1.5 Comments: MATERIAL: 7075-T6 OR T651/T6511/T62 ALUM BAR PER AMS-QQ-A-225/9 OR AMS 4122/4123/4186/4187 OR PER AMS-QQ-A-200/11	30/01/2009	No	16.500000	f	198.00
<div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div>							
<div>Comments: PLEASE DO NOT SHIP ON THE 28TH & 29TH OF JANUARY</div>							
<div>Tax Summary: GST ONT PST</div>					176.83 0.00	Less: included tax	0.00
Entered By: CL CLAVOIE						Subtotal	3,536.50
Approved By: U						Total tax	176.83
						Total purchase order in CAD Dollars	3,713.33

ANALYSIS CERTIFICATE

Empire Resources, Inc.

One Parker Plaza
Fort Lee, NJ 07024-2937
United States
Tel : (201) 944-2200
Fax : (201) 944-2226
dfike@empireresources.com

EMPIRE Letter Ref # : EWR44185



Monday, 28 April, 2008

Date : April 28, 2008
Sales Contract # : E131500
Alloy-Temper : 6061-T6
Container # : EXTR20080414
Case # : EXC16740
Cast # : 18836
Die # : A10023
Specification : .250" X 4" X 20' FLAT BAR 6061, T6
Purchase Order : 073349-AD1
Customer Part # :

S
07/02/02

MADE IN THE USA

Chemical Composition (WT%)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other Elements	
Min	0.40		0.15		0.8	0.04			Each Max	Total Max
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Actual	= 0.6	= 0.22	= 0.21	= 0.07	= 0.87	= 0.06	= 0.02	= 0.017	= 0	

* Aluminum = Remainder

Actual cast analysis is retained on file.

Tensile Properties

Test No.	Yield (ksi)	Tensile (ksi)	Elong. (%)
1	36.3	38.2	16.3

ASTM B221-06. AMS-QQ-A-200/8-97

Ross Toombs

Authorized Signature

Ross Toombs
General Manager

CG755